

Date: Monday, 05/05/2008 11:11:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMREST WELDMENT
 Job Number : 39031
 Estimate Number : 13297
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3785041
 First Issue : / / Type : R & D LG FAB Drawing Number : D3785 PRELIM
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC
 Due Date : 08/05/2008 Qty: 1 Um: Each



FOR ENGINEERING USE ONLY

Additional Product

PROTOTYPE ~~**PRELIMINARY ISSUE**~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D37851 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Tube
 batch: 339032

08-05-14 1

3.0 D37853 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Bracket
 batch: 339033

08-05-14 1

4.0 D37855 Fixture



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Fixture
 batch: 339034

08-05-14 1

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld as per dwg D3785 per QSI004

08-05-26 ① 08-05-14 1

→ 4.1 MS21209F615

Qty: 1 Heli-coil Batch: N/A

ACCEPTABLE TO USE NEW LOCKING


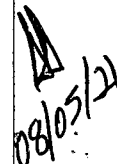
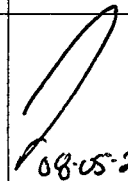
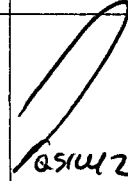
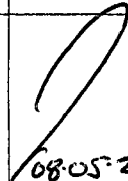
HELI-COIL 08-05-26

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21		Scrap due to material chg S.S. to Alum 6061T6	 08/05/21	Scrap and destroy welded ass'y Redue with new material chg	 08/05/21	 08-05-22	 08/05/22	 08-05-22
		↳ Sub w/p's only		- Replace on this w/p Qty 1 XXXXXXXXXX				

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:48 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST WELDMENT

Job Number: 39031

Part Number: D3785041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/05/27 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



08.05.27

Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.05 Rontype

Job Completion



POSITIVE RECALL

RELEVANT 08.05.05

AUTH

PLEASED 08.05.27

DATE

Small Fabs

→ 7.1 Small Fabs
1- Tap hole for 3/8"-24 heli-coil as per dwg Δ 3785
2- install heli-coil in Δ 3785-5 Fixture as per dwg Δ 3785

080527

7.2 Qc5

08.05.27

MF 08-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3781-041	CUSHION ASSEMBLY	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3781-1	SUPPORTING PLATE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
1	D3781-3	CUSHION	08.04.29	N	END OF MAY	GET QUOTE FROM CHESTNUT RIDGE DAN STOW WILL MAKE ONE FOR TESTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

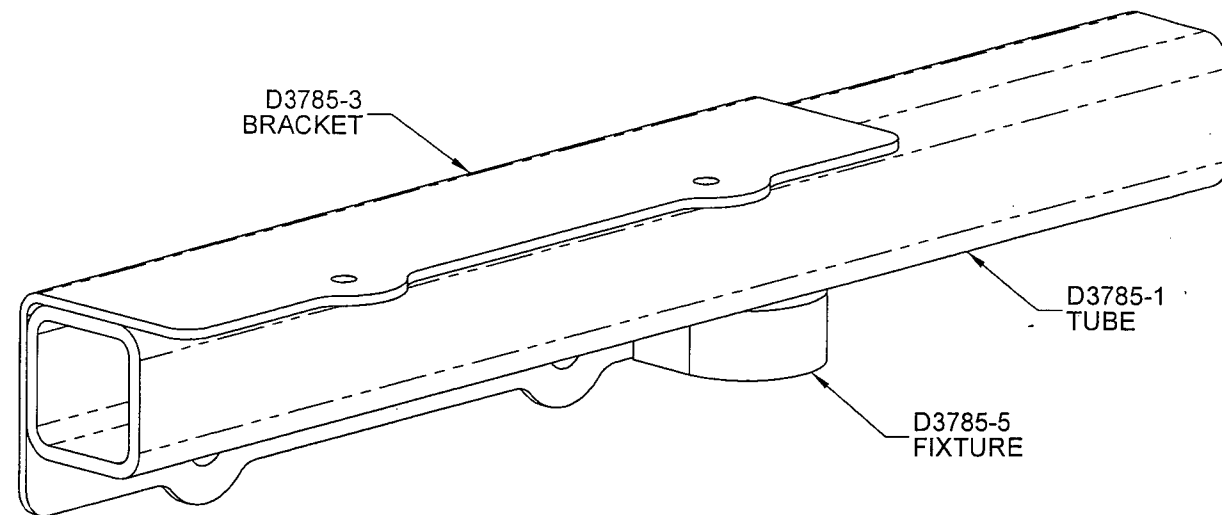
Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

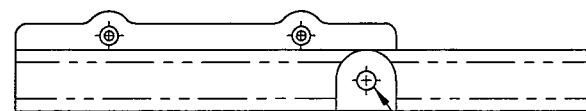
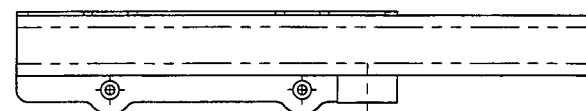
Requested By: _____

Design Manager Approval: _____

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	



D3785-041 ARMREST WELDMENT



INSTALL MS21209F6-15
HELI-COIL INSERT

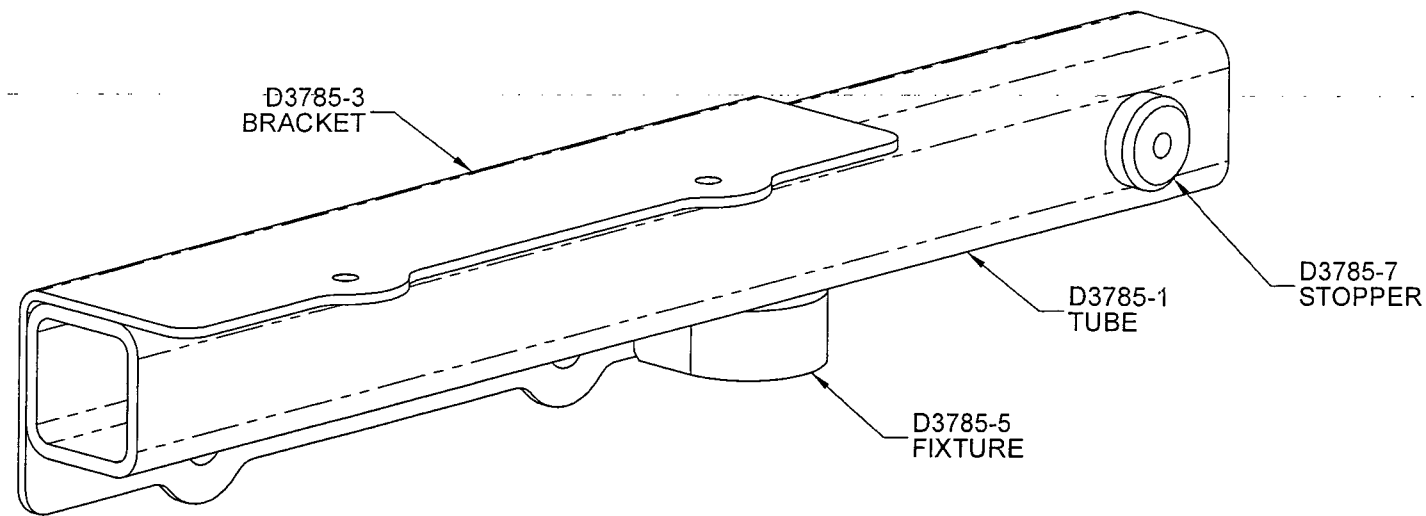
QTY -041	P/N	DESCRIPTION
X	D3785-041	ARMREST WELDMENT
1	D3785-1	TUBE
1	D3785-3	BRACKET
1	D3785-5	FIXTURE
1	MS21209F6-15	HELI-COIL, SCREW LOCKING (RED)

PROTOTYPE

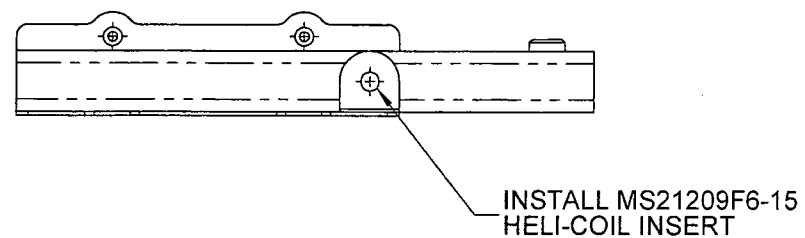
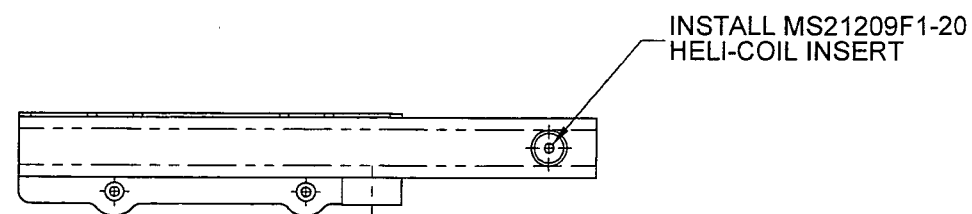
PRELIMINARY ISSUE

08.03.21

A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



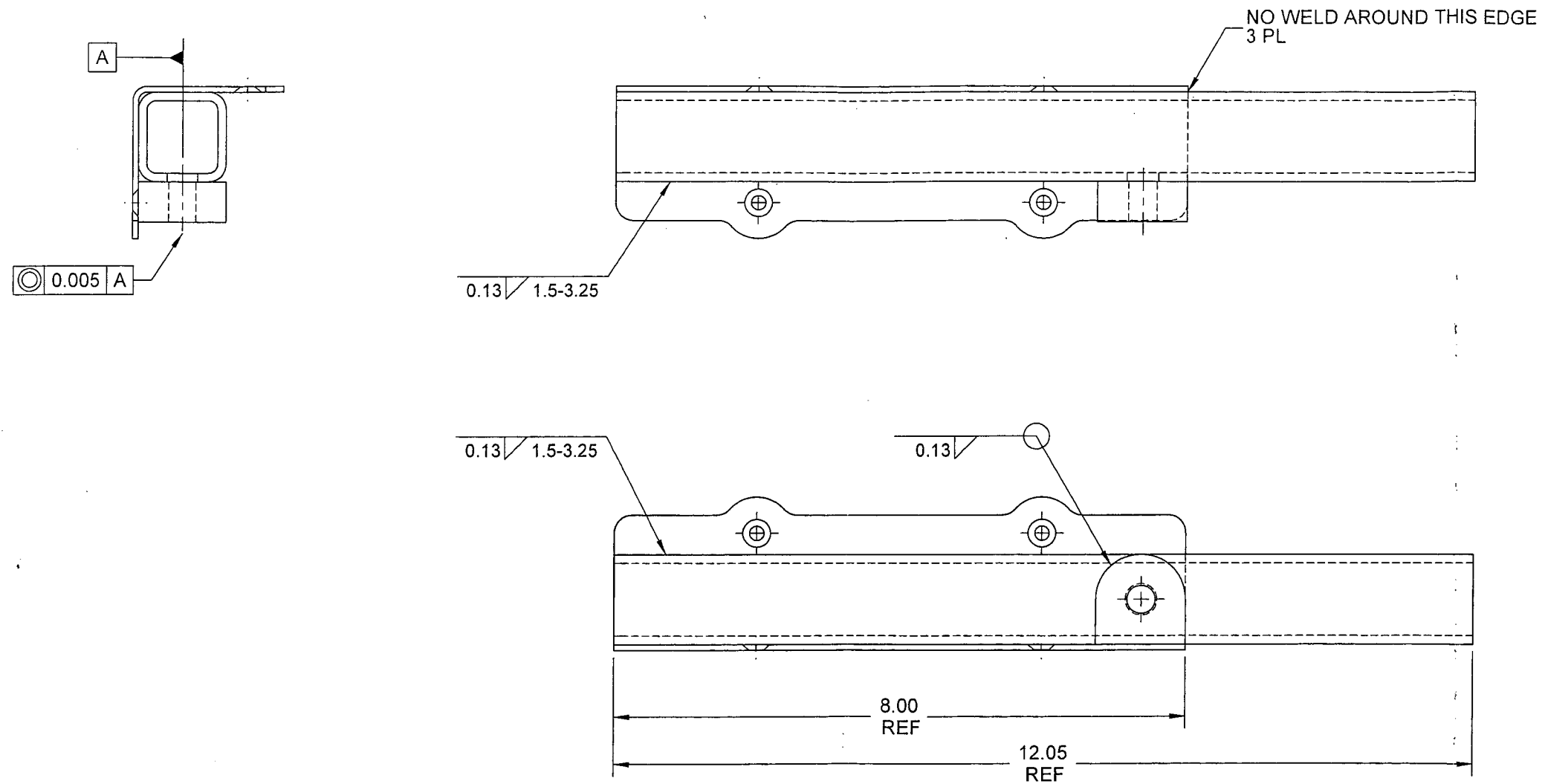
D3785-041 ARMREST WELDMENT



QTY -041	P/N	DESCRIPTION
X	D3785-041	ARMREST WELDMENT
1	D3785-1	TUBE
1	D3785-3	BRACKET
1	D3785-5	FIXTURE
1	D3785-7	STOPPER
1	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
1	MS21209F6-15	HELI-COIL, SCREW LOCKING (RED)

PROTOTYPE
PLEASE RETURN ALL TESTED
DATA TO ENGINEERING
08.04.09

A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



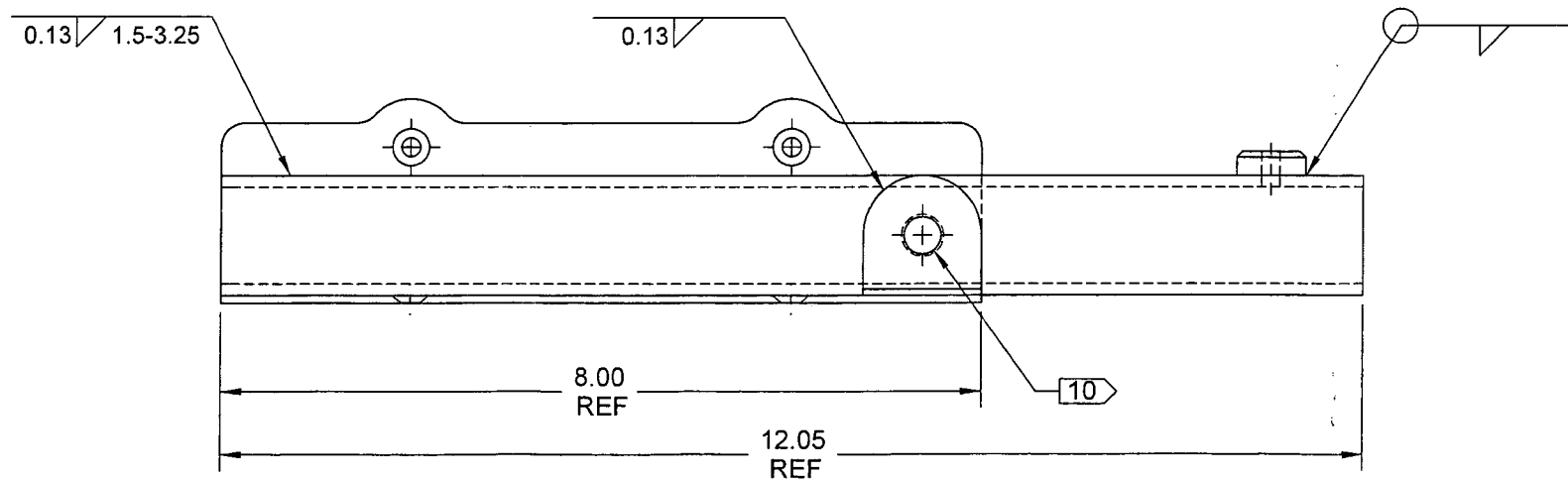
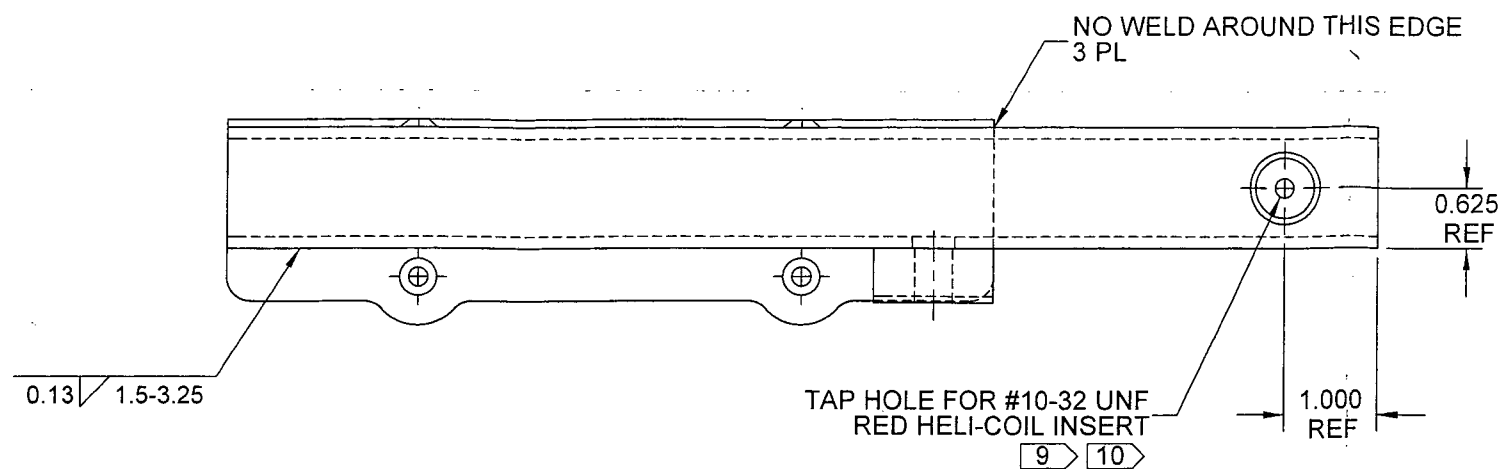
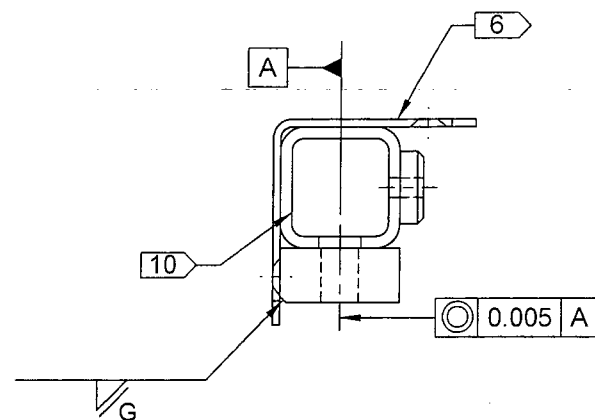
D3785-041 ARMREST WELDMENT WELDING DETAIL

D3785-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.89 lbs
- 8) WELD PER DART QSI 004

PROTOTYPE
~~**PRELIMINARY ISSUE**~~
 130805.21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



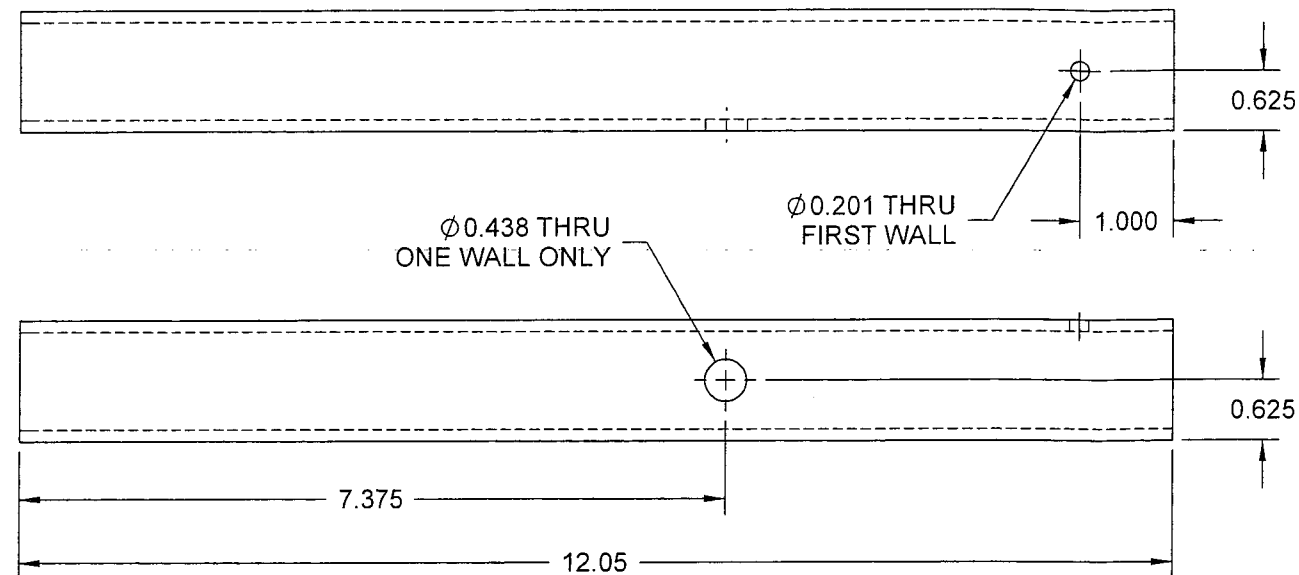
D3785-041 ARMREST WELDMENT WELDING DETAIL

D3785-041 NOTES:

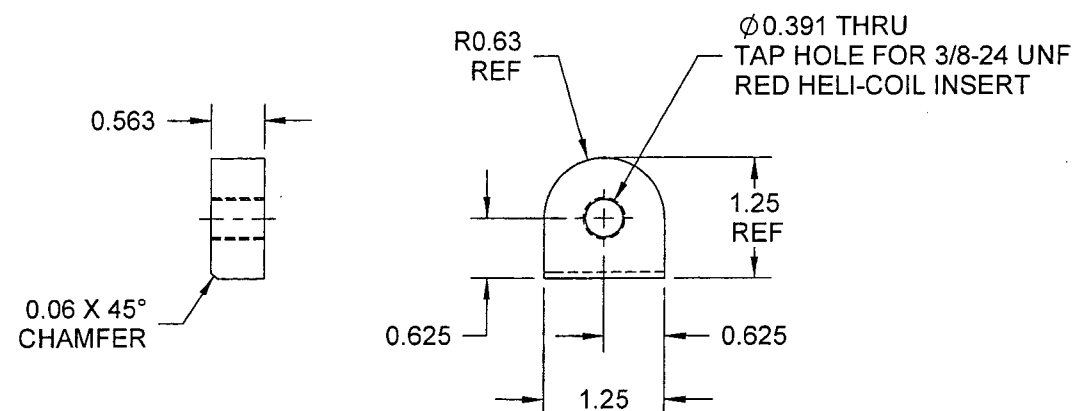
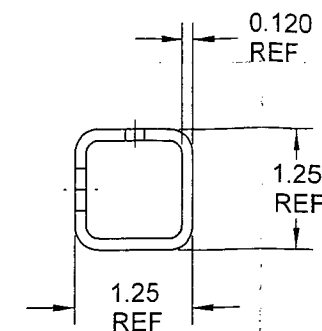
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004
- 9) TAP HOLE AFTER WELDING
- 10) MASK INSIDE OF TUBE AND THREADED HOLES PRIOR TO PAINTING

PROTOTYPE
PLEASE RETURN ALL LOANED
DATA TO ENGINEERING
08.06.07

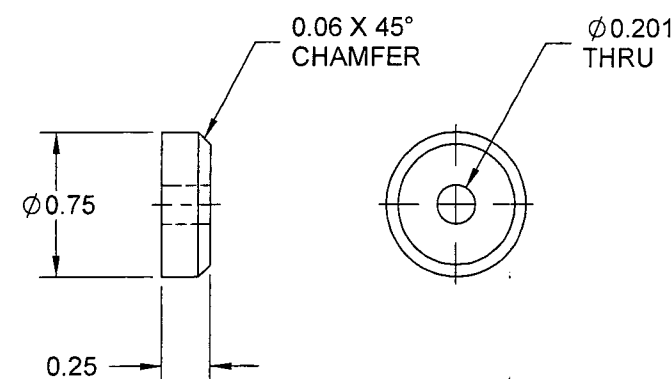
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3785-1 TUBE



D3785-5 FIXTURE



D3785-7 STOPPER

D3785-1/-5/-7 NOTES:

- 1) MATERIAL:
 - D3785-1: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING, 1.25 X 1.25 X 0.120 WALL, PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.250W.120)
 - D3785-5: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
 - D3785-7: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: - D3785-1 = 0.59 lbs
 - D3785-5 = 0.07 lbs
 - D3785-7 = 0.04 lbs

PROTOTYPE
 PLEASE RETURN ALL DATA TO ENGINEER
 13.08.06.05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
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